

**Work Order ID 57686**

Tuesday, April 13, 2010 2:35:32 PM



Page 1

Item ID: D130-780-043

Revision ID:

Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010 Start Qty: 1.00

Required Date: 5/7/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *mf* Date: *10-4-13* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	E
IIN-D130-780	B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels per PPP D130-780-043 CHG 002

*Solo 4/27*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*ST**10-04-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57686**

Tuesday, April 13, 2010 2:35:32 PM



Page 2

Item ID: D130-780-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 		0.00							
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE PER DWG D3186								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

RT 10-04-21

S. L. L. L. L.

Q

10-4-27 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 57686**

Tuesday, April 13, 2010 2:35:32 PM



Page 3

Item ID: D130-780-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S w/b 4/10/07

0.00

Memo

160



Packaging

Packaging

Memo  
Identify and pack for shipping as per PPP D130-780-043  
Location: \_\_\_\_\_  
PPP Rev: A

0.00

0.00

PPP 57688

10-4-27 SP

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/04/28 JF

MF

10-4-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, April 13, 2010 2:35:31 PM

Page 1

Work Order ID: 57686

Parent Item: D130-780-043

Parent Item Name: Spacepod Door Assembly, LH

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:B add  
route seq DD 10.03.03 verified by:EC

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J		Purchased	No			110	Each	602.0000	16.0000			
WASHER												

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST275 394

114340 394

Main Warehouse

ST297 8

114108 8

Main Warehouse

ST298 200

114348 200

D3186-3 Manufactured No



Spacepod Door, LH

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

CA 1

52522 1

D2464-1250 Manufactured No



Neoprene Seal

114340.?

x 16



RT 10-04-13

B 53080

0.0000 1.0000



B 48123

RT 10-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, April 13, 2010 2:35:31 PM

Page 2

Work Order ID: 57686



Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3837-3		Manufactured	No			110	Each	20.0000	1.0000			
Decal												

BT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST092

20

46232

9

56380

11

XL

D2586

Manufactured No

110

Each

86.0000

2.0000



Door Latch



BT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST204

86

55314

86

X 2

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, April 13, 2010 2:35:31 PM

Page 3

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Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585		Manufactured	No			110	Each	107.0000	2.0000			
											85	10-04-13
Mounting Channel												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST018                      62

53798                      2

55313                      60

Main Warehouse

ST019                      45

56524                      45

D2621

Manufactured      No

110                      Each                      118.0000      2.0000



Latch Plate, 350 Spacepod



85 10-04-13

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST021                      118

46842                      49

56526                      69

x 2

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, April 13, 2010 2:35:31 PM

Page 4

Work Order ID: 57686



Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No			110	Each	137.0000	2.0000			
Screw											RT 10-04-13	

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST292

137

112794

37

114056

100

NAS1149D0363J

Purchased

No

110

Each

1,898.000

2.0000



Washer

RT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST298

1898

113288

42

114292

1856

MS21042L3

Purchased

No

110

Each

1,235.000

2.0000



Nut

RT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST300

1235

113537

251

113644

984

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, April 13, 2010 2:35:31 PM

Page 5

Work Order ID: 57686



Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1		Manufactured	No			110	Each	38.0000	1.0000			
Hinge Bracket												

RT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST026

38

55019

19

56529

19

X1

D2857-2 Manufactured No

110

Each

48.0000

1.0000



Hinge Bracket



RT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST027

48

55020

28

56530

20

X1

D2228 Manufactured No

110

Each

62.0000

4.0000



Bracket Plate



RT 10-04-13

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST009

62

30679

15

48228

47

X4

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, April 13, 2010 2:35:31 PM

Work Order ID: 57686



Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R10		Purchased	No			110	Each	183.0000	10.0000			



Screw



RT 10-04-13

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST327

183

04603

33

113154

100

113288

50

X 10

MS21042L08

Purchased No



Nut

110

Each

774.0000

14.0000



RT 10-04-13

PTO

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST300

400

114330

400

Main Warehouse

ST301

374

114056

174

114227

200

X 14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-04-14		MS21042L08 Qty need to be changed to 16 MS21042L08 x2 B <u>114056</u>	ST	10-04-14			J 10/04/14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, April 13, 2010 2:35:31 PM

Page 7

Work Order ID: 57686

Parent Item: D130-780-043

Parent Item Name: Spacepod Door Assembly, LH



Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:B add  
route seq DD 10.03.03 verified by:EC

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3557-1		Manufactured	No			110	Each	19.0000	1.0000			
												
Bracket											ET 10-04-13	

Warehouse  
Location

Main Warehouse

ST070

19

46887

4

50283

15

D3554-7

Manufactured No

110

Each

45.0000

1.0000



Ball Stud



ET 10-04-13

Warehouse  
Location

Main Warehouse

ST070

45

37674

45

NAS1149D0563J

Purchased No

110

Each

1,909.000

1.0000



Washer



ET 10-04-13

Warehouse  
Location

Main Warehouse

ST298

1909

113524

44

113706

1865

X1

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, April 13, 2010 2:35:31 PM

Page 8

Work Order ID: 57686



Parent Item: D130-780-043



Parent Item Name: Spacepod Door Assembly, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3		Manufactured	No			110	Each	126.0000	1.0000			



Locknut



RT 10-04-13

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST033

126

43758

26

48238

4

56701

96

X 1

AN526C832R14

Purchased

No

110

Each

786.0000

2.0000



Screw



RT 10-04-13

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST327

786

104916

786

140

Each

0.0000

1.0000

C 2732-25

D2589

Manufactured

No



Keys, Key Chain, 350 Hinge

2x

X 2



347183 10-4-27 SP

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 8

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 9

Work Order ID: 57686

Parent Item: D130-780-043

Parent Item Name: Spacepod Door Assembly, LH

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM  
route seq DD 10.03.03 verified by:EC

IPP Rev:B add

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------



Door Prop

Manufactured

No

140

Each

11.0000

1.0000



1357-731 10-4-27SP

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST272

11

32644

1

52451

10

MS27039-08-11

Purchased

No

110

Each

71.0000

2.0000



Screw



ST 10-04-14

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST290

71

111977

21

113749

50

NAS1515H3

Purchased

No

110

Each

152.0000

2.0000



Washer



ST 10-04-14

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST277

152

111268

152

X2

Tuesday, April 13, 2010 2:35:31 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

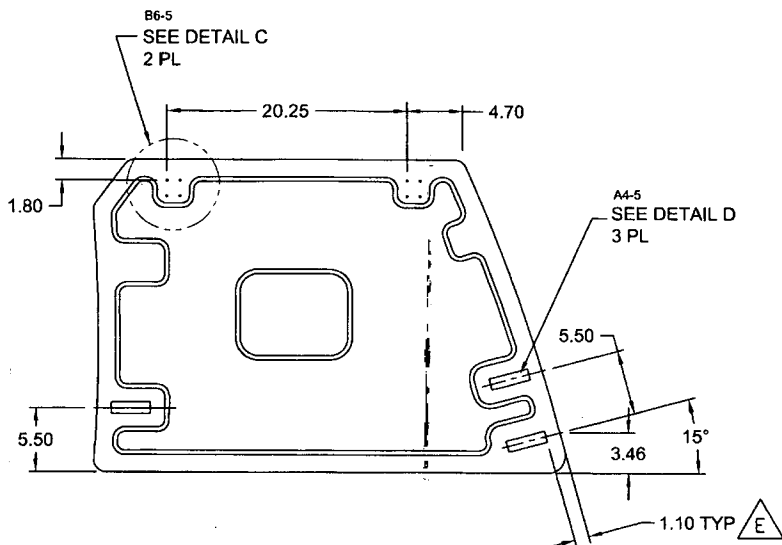
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

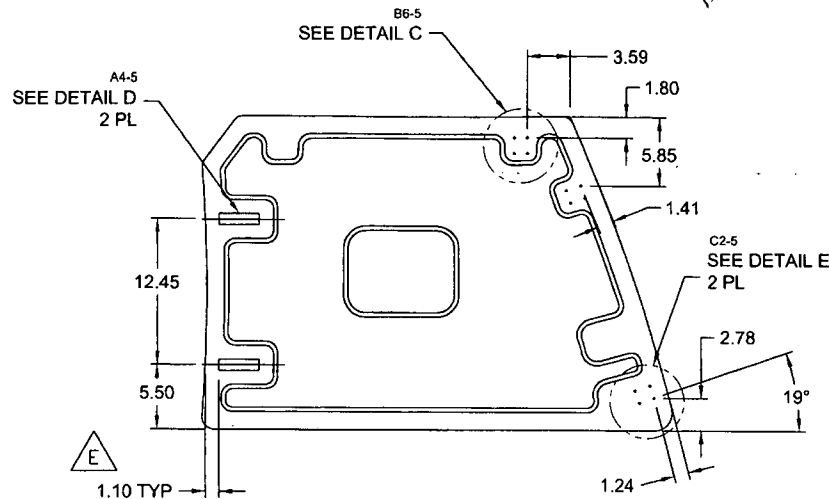
#57686



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**RELEASED**  
2008-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. E D3186 SHEET 1 OF 5 TITLE SCALE SPACEPOD DOOR NTS DATE 09.07.08 <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		

8 7 6 5 4 3 2 1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

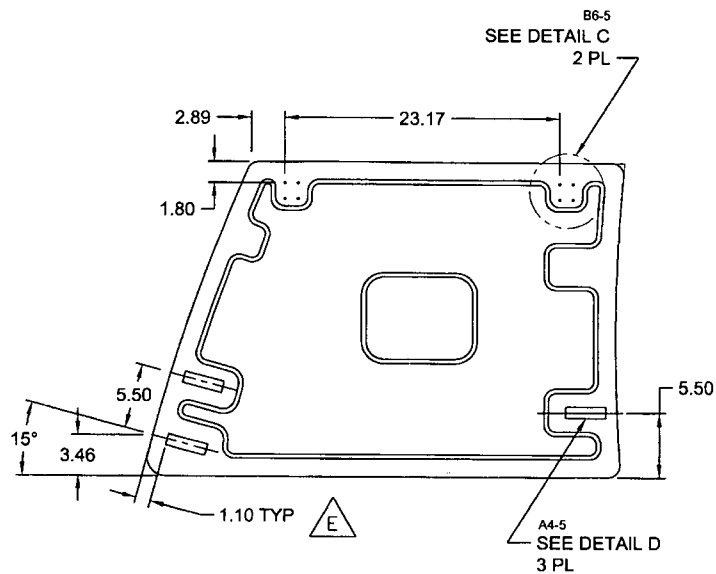
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

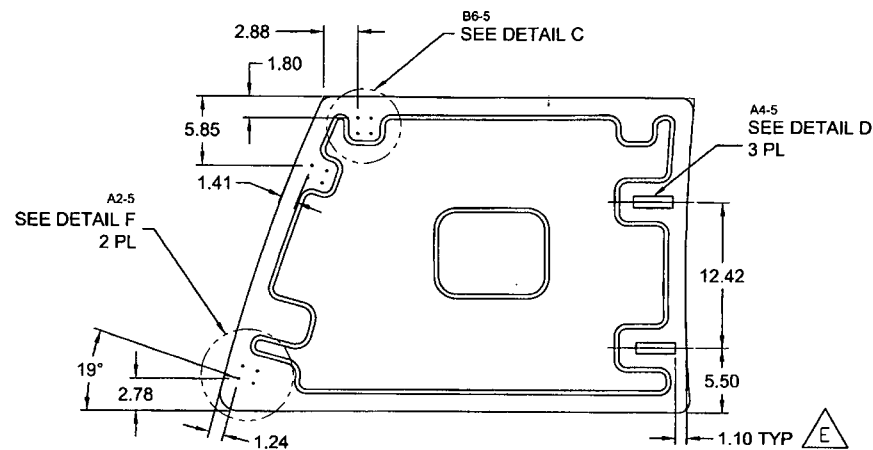
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#57686



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2008-09-09

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

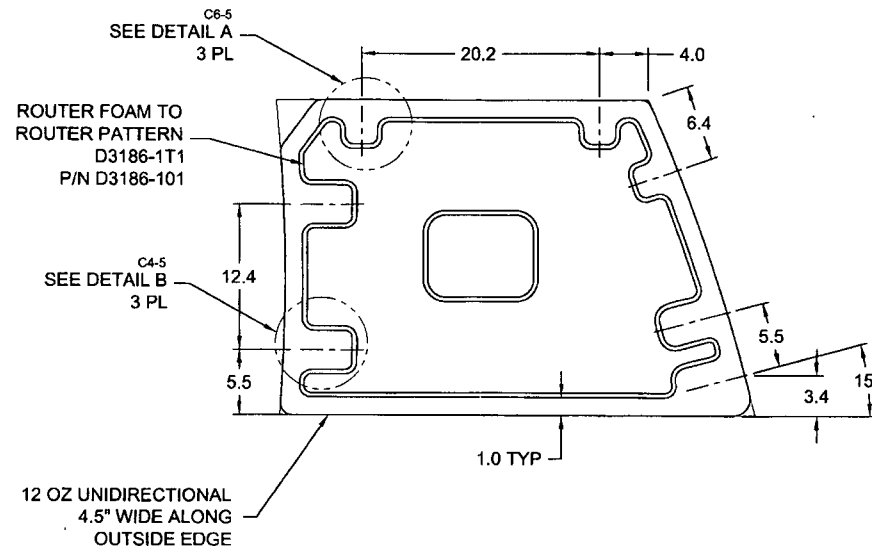
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3186-1M SPACEPOD DOOR AS MOLDED**

**MAIN LAYUP**  
 9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY

#57686

**NOTES:**

**1) MATERIAL:**

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL

FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

**2) FINISH:** FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

**3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED

**4) UNITS:** INCHES UNLESS OTHERWISE NOTED




**5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX

**6) IDENTIFICATION:** NONE

**7) WEIGHT:** 7.0 lbs

**8) USE MOLD DT8005 FOR DOOR LAYUP**

**RELEASED**  
 2009-08-08

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

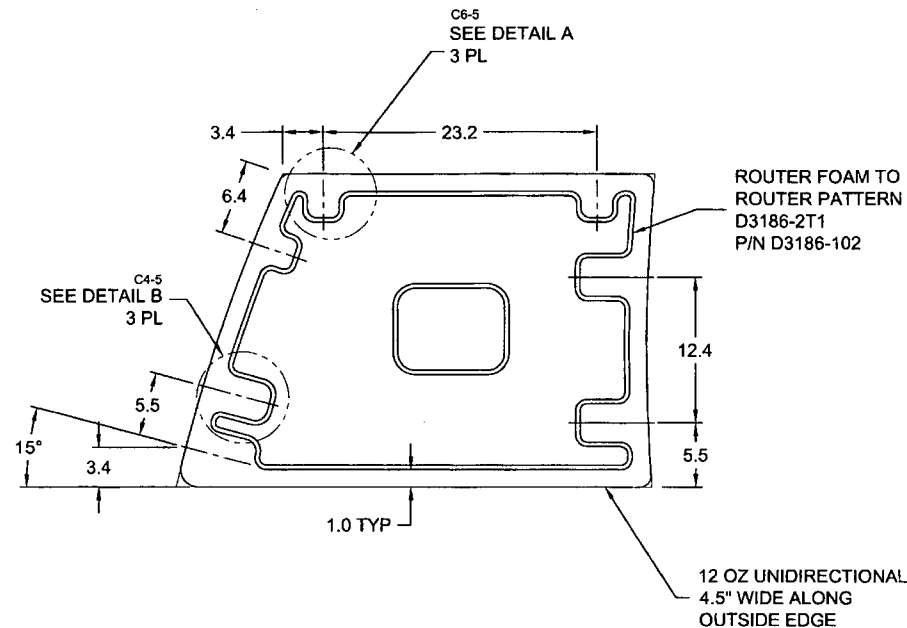
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY



#57686

## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

## D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED  
 2009-09-09  
 JWP

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D3186	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

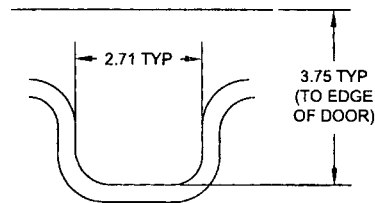
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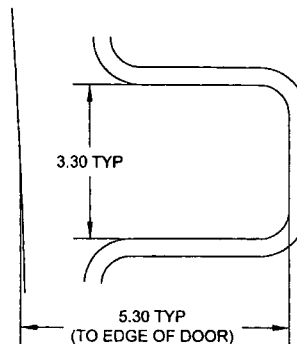
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

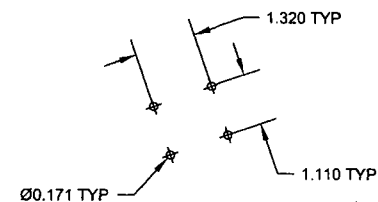




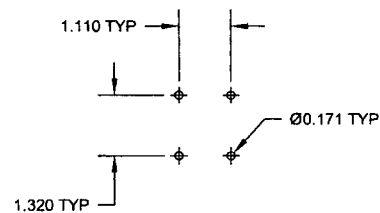
**DETAIL A** D6-3  
SCALE 4X D4-4



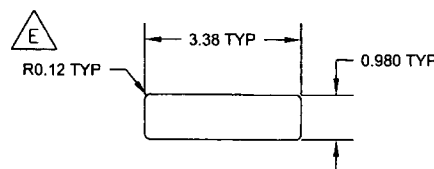
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

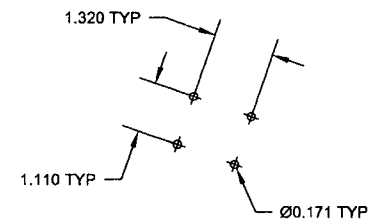


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-08

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries